	ON FACE OF DWG. & IN B/M	
	28C004-6 WAS 22C117-1N	
	B/M 22C012 WAS 22C112	
	NO WT. CHG.	
	ADDED NOTE READING	
	28C004-6 MAKE FROM	
	22C117.	
2	ADDED 28E5853 R/L	
	28E5864 FOR -50 ASSY.	
	RESTRICTED 28E5853 R/L	
	& 28E5864 TO MCR-1A.	
	WT. 10.56 # WAS 16.2 #	

MCR-1A

(2) SEE DETAIL
RIVET WITH
AN442-D8-3

CUT HOLE IN TUBE
TO MATCH HOLE
IN CASTING

DRILL 7/64 - 2 HOLES
JIG DRILL TO MATCH
PINS ON 28F1497

DRILL #10 (.193) 4 HOLES THRU
FOR PBY-2 & -3 ONLY
AN 3-16 (4)
AN 310-3 (4)
AN 380-2-2 (4)

CUT OUT ON
PBY-2 & -3 ONLY

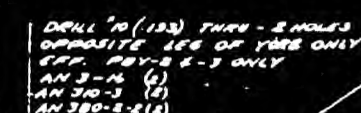
CUT HOLE IN TUBE TO
MATCH HOLE IN
REINFORCEMENT

AN442-D6-6

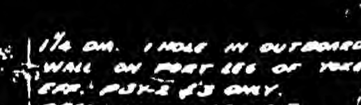
(2) SEE DETAIL
RIVET WITH
AN442-D4-9

NOTE ~
-5 IS FLUSH WITH RIVET HEADS

DRILL #10 (.193) THRU - 2 HOLES
OPPOSITE LEG OF YOKE ONLY
AN 3-16 (2)
AN 310-3 (2)
AN 380-2-2 (2)



1 1/8 DIA. 1 HOLE IN OUTBOARD
WALL ON PORT LEG OF YOKE
FOR PBY-2 & -3 ONLY
BREAK INSIDE OF HOLE



3 1/4 FOR PBY-1 ONLY

AN442-D4-7
28E5853-L
28E5853-R
28E1138 NOT USED ON -400 ASSEM.
28C012 2 REQD
28E5864
AN442-D4-8
NOTE ~ THIS RIVET USED ON -400 ASSEM. ONLY
28E6135 FOR -50 ASSY ONLY
NOTE ~ TOP OF BRACKET IS FLUSH WITH TOP OF TUBE
MAKE FROM 22C117
FINISH ~



.031 STAINLESS STEEL SHEET
FABRIC IMPREGNATED WITH BITUMASTIC

28C009
28C1154 -1 OPP.
28C026-R
28C5136-L

DETAIL OF (2)
3/16 SHEET 24ST AL ALLOY
SPEC. 47A10 COND. T
ALLOY 24-T

SECTION A-A

NOTE ~
INSTALL -3 PARTS
ON PORT SIDE ONLY

DRILL #10 (.193)
AN442-D6-7

NOTE ~
TRIM ENDS OF
THESE BOLTS IF
NECESSARY TO CLEAR
CONTROL CABLES

28C1154-1

REAM .2495 .2480
5 HOLES WITH 28C1154-1
AN 24-12 3 PLACES
AN 320-4 5 REQD
AN 380-2-2 5 REQD
AN 24-9 2 PLACES

H 181

APPROVED FOR TOOLING

FILE

COPY No. 2